

SLIT HSAD

Date: Monday, 7/16/2007 2:48:02 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 33566	
Estimate Number : 10012	
P.O. Number : N/A	Part Number : D27363
This Issue : 7/16/2007 S.O. No. : N/A	Drawing Number : D2736 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 33082	Material : N/A
Written By : [Signature]	Due Date : 8/5/2007 Qty: 40 Um: Each
Checked & Approved By : [Signature] 07.07.17	
Comment : Est Rev:D Removed from 9 digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2591 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2591	Lug	B 33086

07/10/11

20x

2.0 D27353 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2735-3	Lug Bracket	B 32771

07/10/11

20x

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: M103794

07/10/11

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-12

20

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/25

counted

20

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 33566

Part Number: D27363

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M105068



(20x)

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

m-k 07/10/25

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



gs



(20x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-25

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 471A

7/10/26

(20x)

sp

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(20x)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/06

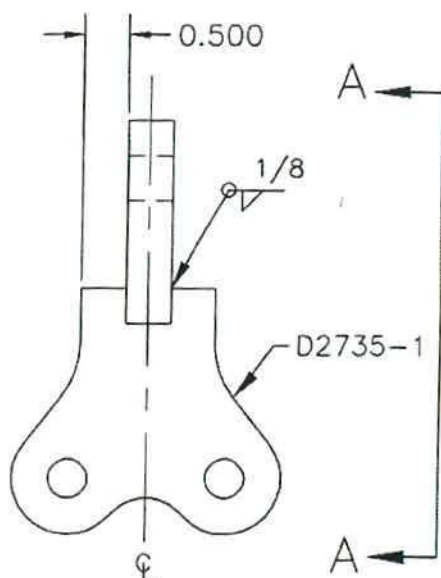
Job Completion



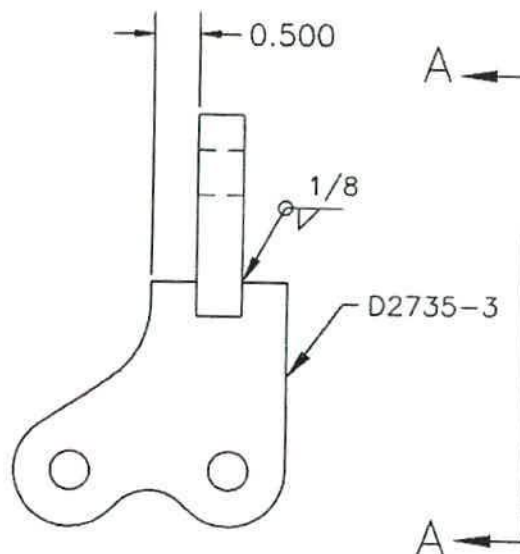
U 07-10-26



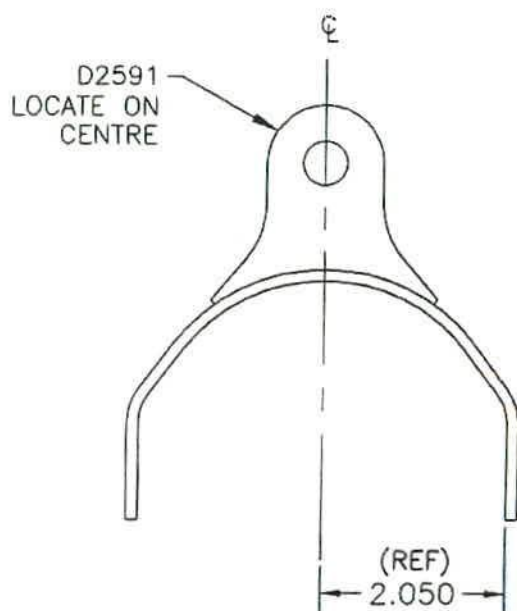
DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

RELEASED
97/12/24 DS

ECN 057

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33566